

Date: Thursday, 4/12/2007 8:46:19 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	BRACKET
Job Number	31733	Part Number	D31451
Estimate Number	11479	Drawing Number	D3145 REV B
P.O. Number		Project Number	N/A
This Issue	4/12/2007	Drawing Revision	B
Prsht Rev.	NC	Material	
First Issue	/ /	Due Date	5/10/2007
Previous Run	26502	Qty:	6
Written By		Um:	Each
Checked & Approved By	<u>07.04.12</u>		
Comment	Est. A 03.02.28 New issue KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	M6061T6B2000X02000	6061-T6 Bar 2.0" x 2.0"	
		Comment: Qty.: 0.4025 f(s)/Unit Total : 2.4148 f(s) 6061-T6 Bar 2.0" x 2.0" Material: 6061-T6/T651 (QQ-A-200/8 or QQ-A-225/8) M6061T6B2,000x2,000 Batch: M16724	
2.0	BAND SAW	BAND SAW	
		Comment: BAND SAW Cut blanks: (2.00" x 2.00") x 4.500" (+0.030/-0.00) Long Bar	J.L 08/06/04
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	 PTO
		Comment: HAAS CNC VERTICAL MACHINING #1 Machine per Folio FA318 and Dwg D3145 Deburr and Tumble	8/08/07/03
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	 8/08/07/03
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	(6)
5.0	QC8	SECOND CHECK	 RQ 08/07/03
		Comment: SECOND CHECK	(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3145-1 PAR #: N/A Fault Category: Prod/Machined Part NCR: Yes No DQA: Date: 28/07/11
 D412 - 694 - 073 QA: N/C Closed: Date: 28/07/11

NCR: 31733		WORK ORDER NON CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/07/04	3.0	Scrap parts #3 and #4 Because they move move in the jig and the tolerance of .219 is under.	08.07.04	Place skin in front and Behind pit bull clamp	S.E. 08/07/04	08/07/04	08/07/04	08/07/04
		PC use station + pit bull station clamp was not tightening enough		Scrap and Destroy and Replace B# <u>16724</u>		08/07/04	08/07/04	08/07/04

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 31733

Part Number: D31451

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BL 08-07-07

07/07/2008

S.033 13.08

#1 319.5 F

#2 - F

#3 - F

#4 ---

P31451

331733

30mins

7.0 POWDER COATING

POWDER COATING



m10792S

08-07-07

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

BL 08-07-07

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BL 08-07-07

X6

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 68

8/1/9

SG

10.0 QC21

FINAL INSPECTION/W/O RELEASE



08/07/10

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-07-10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31733
Description: Bracket	Part Number:	D3145-1
Inspection Dwg: D3145	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

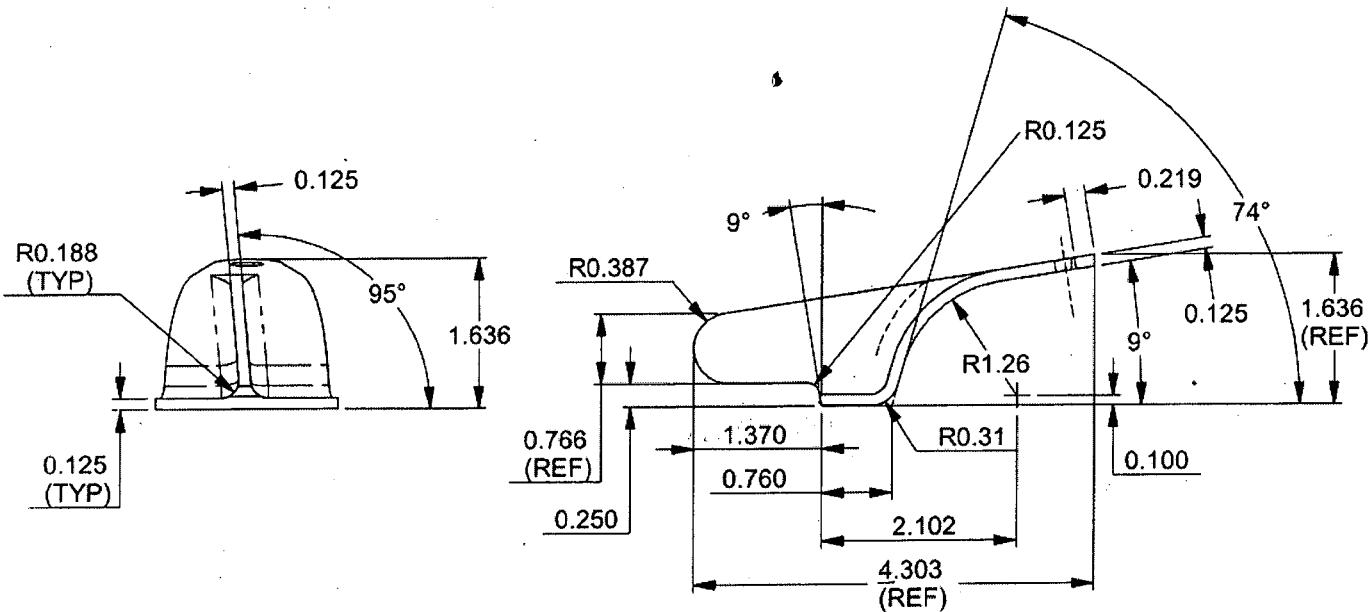
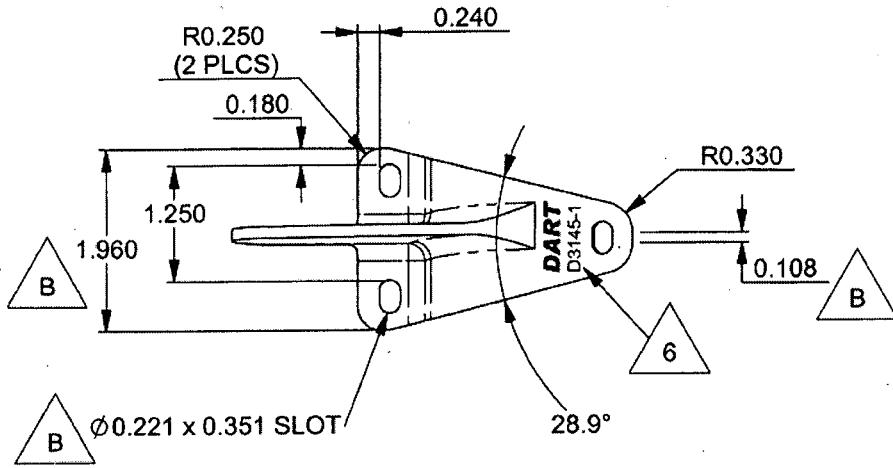
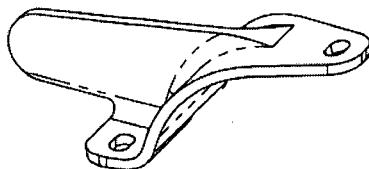
X First Article Prototype

Measured by:	J.L	Audited by:	J.S	Prototype Approval:	N/A
Date:	08/07/03	Date:	10/07/03	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue	KJ/JLM	<i>[Signature]</i>

DART

DESIGN <i>RF</i>	DRAWN BY <i>JP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MF</i>	APPROVED <i>MF</i>	DRAWING NO. D3145	REV. B SHEET 1 OF 1
DATE 03.02.06		TITLE BRACKET	SCALE 1:2
A	02.04.24	NEW ISSUE	
B	03.02.06	ADD SLOTS; WIDEN TABS; 1.960 WAS 2.000	

RELEASED03.03.18 *MF*

D3145-1 BRACKET SHOWN. REPLACES PREMIER P/N B30-23000-25
(D3145-2 BRACKET OPPOSITE. REPLACES PREMIER P/N B30-23000-26)

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) BAR (REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N AND LOGO AS SHOWN

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *31733*

